

# Work Order ID 78880

\*78880\*

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January-16-12 4:28:59 PM

Item ID: D3248-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 16/01/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 12/01/16

Tooling:

Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3248	Rev A					9			

100 0.00

\*100\*

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

5052 .063

2-Deburr if necessary

110 0.00

QC2- Inspect parts off machine FAI/FAIB

\*110\*

QC

Memo

0.00

Quality Control

1812-6-26

1812-6-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 78880

\*78880\*

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January-16-12 4:28:59 PM

Item ID: D3248-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Doubler  
 Start Date: 16/01/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 30/01/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				(+9)			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				9	2/6	120-27	
140 *140* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<del>7X</del>	<del>8D</del>	<del>120-27</del>	<del>12/4/27 (9)</del>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*78880\***

January-16-12 4:28:59 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 16/01/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 30/01/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: ST 30

0.00

**\*150\***

## Packaging

## Memo

0.00

## Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

QX

12-6-27

12/4/28 JJ

ME 12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 78880

\*78880\*

Parent Item: D3248-1

\*D3248-1\*

Parent Item Name: Doubler

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3248-1 no longer made in-house.  
11.02.07 now made on W.J. DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	27.5000	0.0937	0.394526	1,		

\*M5052H32S 063\*

\*\*

B12-6-76

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

27.5

114322

27.5

120603

12063

9

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

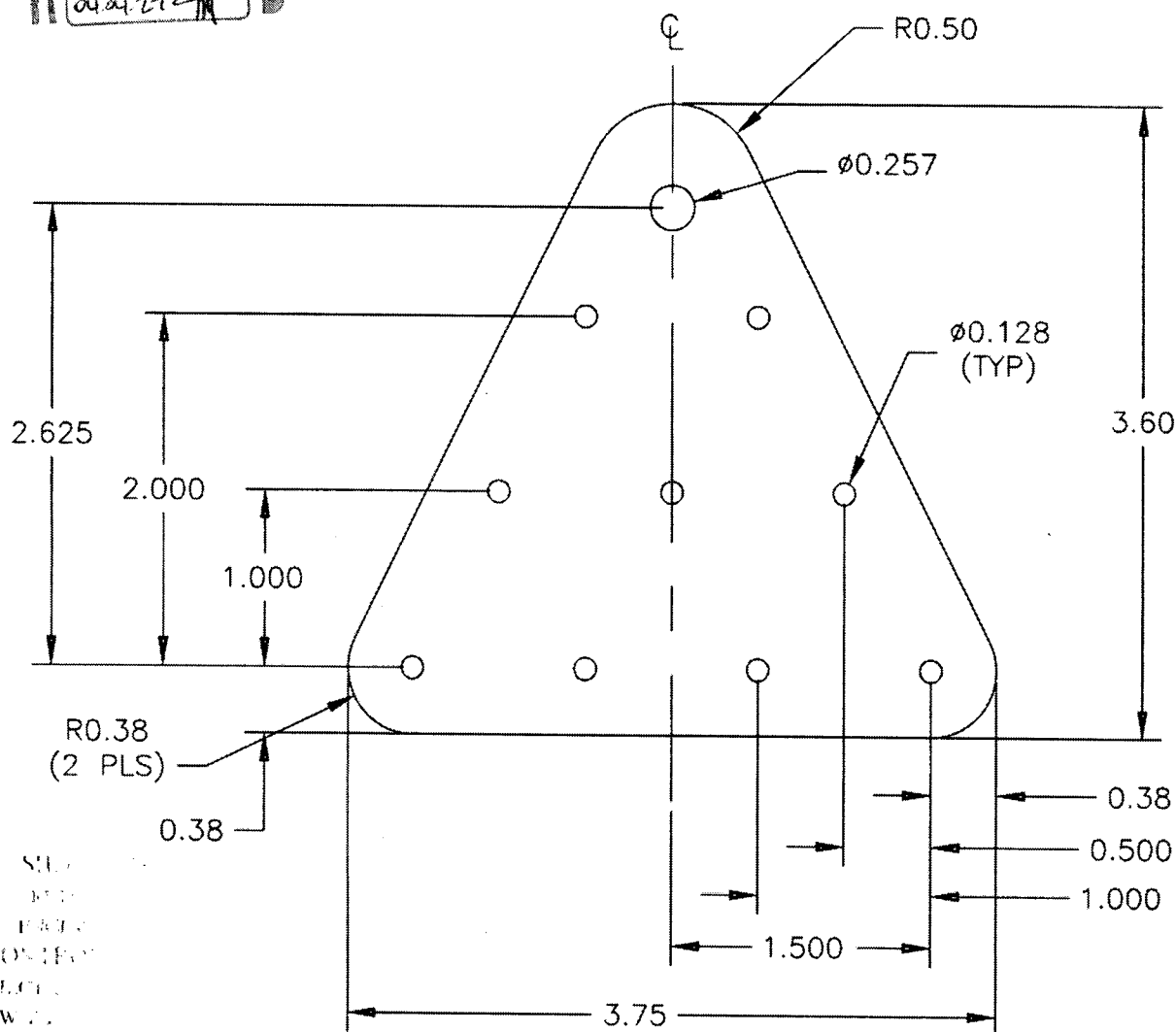
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3248	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE DOUBLER	SCALE 1:1
A	04.04.06	NEW ISSUE	

RELEASED  
04.04.27



SUBJECT  
UNCONTROLLED  
SUBJECT

NO. 7.8.880 M.L.J

D3248-1

NOTE:

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.063 THICK (REF. DART SPEC. M5052H32S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) PART IS SYMMETRIC ABOUT CENTERLINE

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